



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE-350DAMPER-03
Job Sheet 191764



Part No: RBE-350DAMPER-03

Job Qty: 4 pcs

Part Name: Adjustable spanner



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Mill - 1	4 pcs	4/12/19		0.50	0.67	Conventional Mill - 1		
							Conventional Mill - 2		
110	QC 2	4 pcs	4/12/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S168040



Part: RBE - 350DAMPER - 03

Job No: 191764

Serial No/Batch: S168040

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/01/19

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120 QC 8	4 pcs	4/12/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	5 = 19-04-02
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
130 Packaging 3-1 - Stock - B4B	4 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EC
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA	4 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	S-85
				QC 21 - SA - 53	APR 02 2019
Part Op 100 - (Manufacture as per dwg), 1- Machine as per DWG. 2- Deburr 3-Use jaws DT10373 4- Engrave T/N And / or S/N Descriptions: number as required Using Marktronic engraver as per DWG. 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____), IDENTIFY AND STOCK 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
5481A1	Adjustable Spanner	4 Ea (1 ea)	100-Conventional Mill - 1	S083963 GA061	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Conventional Mill - 1	5481A1	4	16	0	
Part Specifications					
Specifications could not be found.					

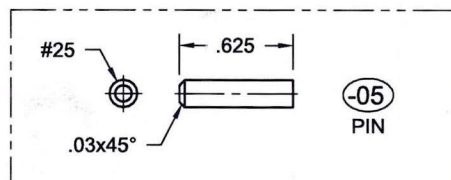
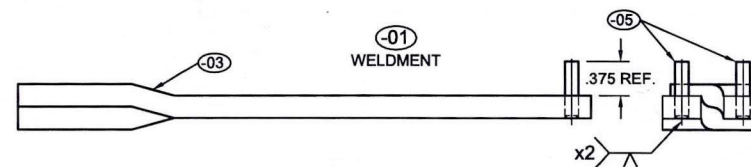
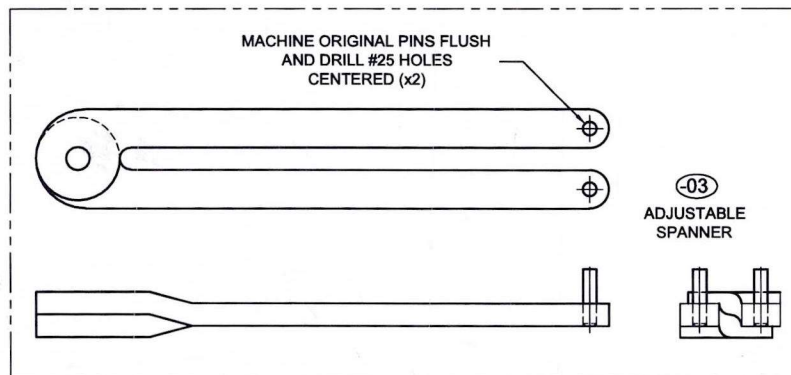
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL / APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP DW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

N 191764 MWS
19-03-07



FUNCTION: USED TO REMOVE DAMPER CAP

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
	ASSY -01						

RED BARN MACHINE		TITLE	
		DAMPER SPANNER WRENCH	
DWG NO.		RBE-350DAMPER	
REV		1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED <i>D. Weil</i>	
DECIMALS .XXX ± .005		HEAT TREAT	
FRACTIONS ± 1/32		FINISH SPEC	
ANGLES ± 5°		BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED		USED ON MODEL	
1. BREAK ALL SHARP EDGES		EUROCOPTER AS350/355	
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	9-9-09
		SHEET	1 of 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					